

Date: Wednesday, 10/09/2008 3:46:09 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 41954		
Estimate Number	: 11288		
P.O. Number	:	Part Number	: D34375
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: D3437 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 34314	Material	:
Written By	:	Due Date	: 05/10/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>JLD 08.9.11</u>		
Comment	: Est. A 05.05.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR .500
-----	-----------	------------------



Comment: Qty.: 0.4025 f(s)/Unit Total: 2.4148 f(s)

303 HEX BAR

Material : 303 Hex Bar 0.5"(M303H0.500)

Identify for D3437-5

Batch: 109778 Dwg Rev. B DTP 08/11/05

(6)

2.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE

Turn as per Dwg D3437

Deburr

08/11/06DTP 08/11/05

(6)

(P007)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/11/06

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/11/06 (5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/11/11 (5) (P00 41932)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3437-5 PAR #: N/A Fault Category: Prod. Mach NCR: Yes No DQA: lt Date: 08-11-13
 (D205-633-025/-026) Resolution: Scrap Disposition: Scrap QA: N/C Closed: tg Date: 08/11/20

NCR: <u>41954</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/16	#20	operator noticed that two holes were drilled on one part. E. (other shift shift operator drilled at the part wrong. Lack of attention	<u>08/11/16</u>	Scrap and Destroy no Replace.	<u>08/11/16</u>	<u>08/11/16</u>	<u>08/11/16</u>	<u>08/11/16</u>

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:46:09 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 41954

Part Number: D34375

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

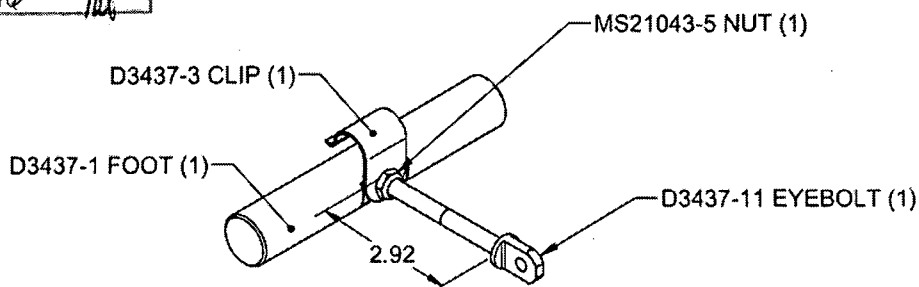
NOTE: Date & initial all entries



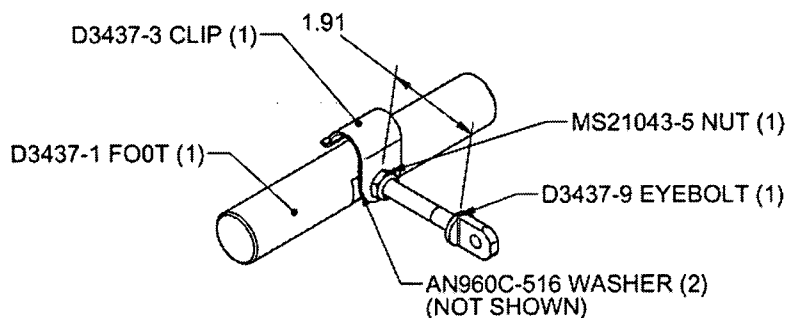
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 1 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED

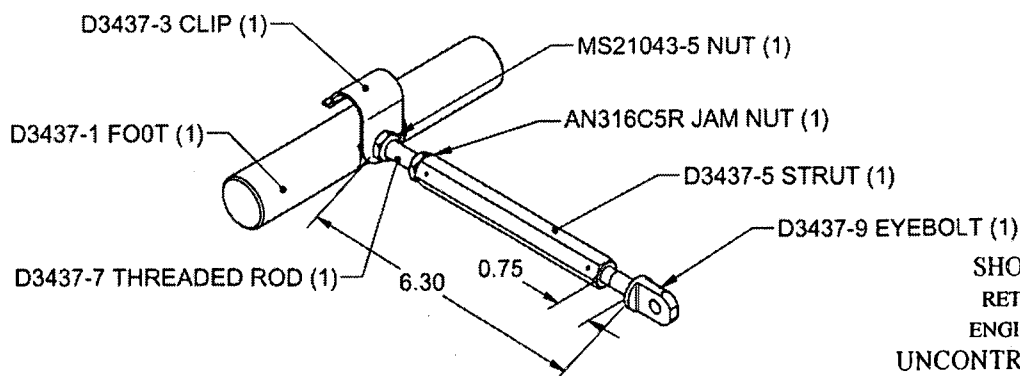
05.08.11 *[Signature]*



D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

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WORK ORDER
NO. 41954

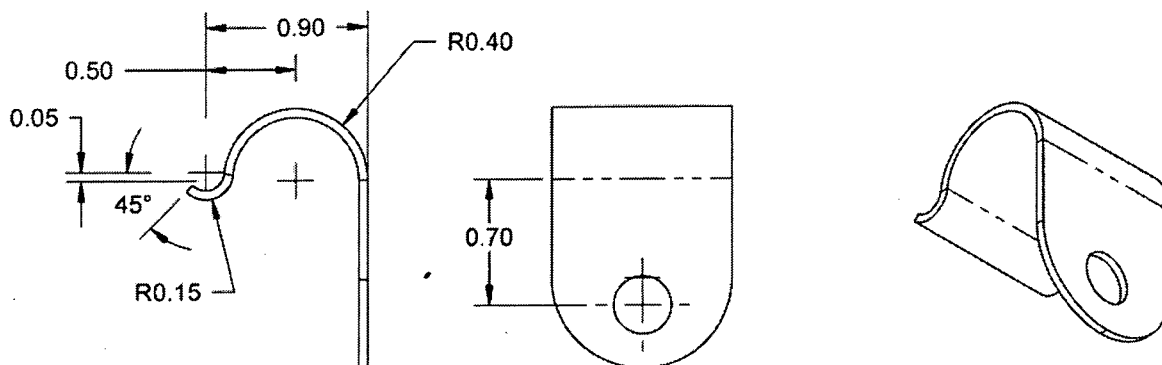
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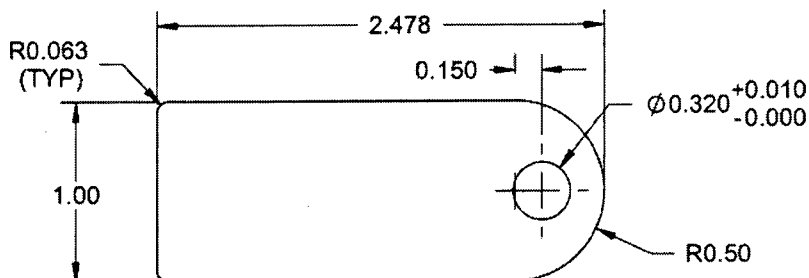


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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED
05.08.16 *[Signature]*



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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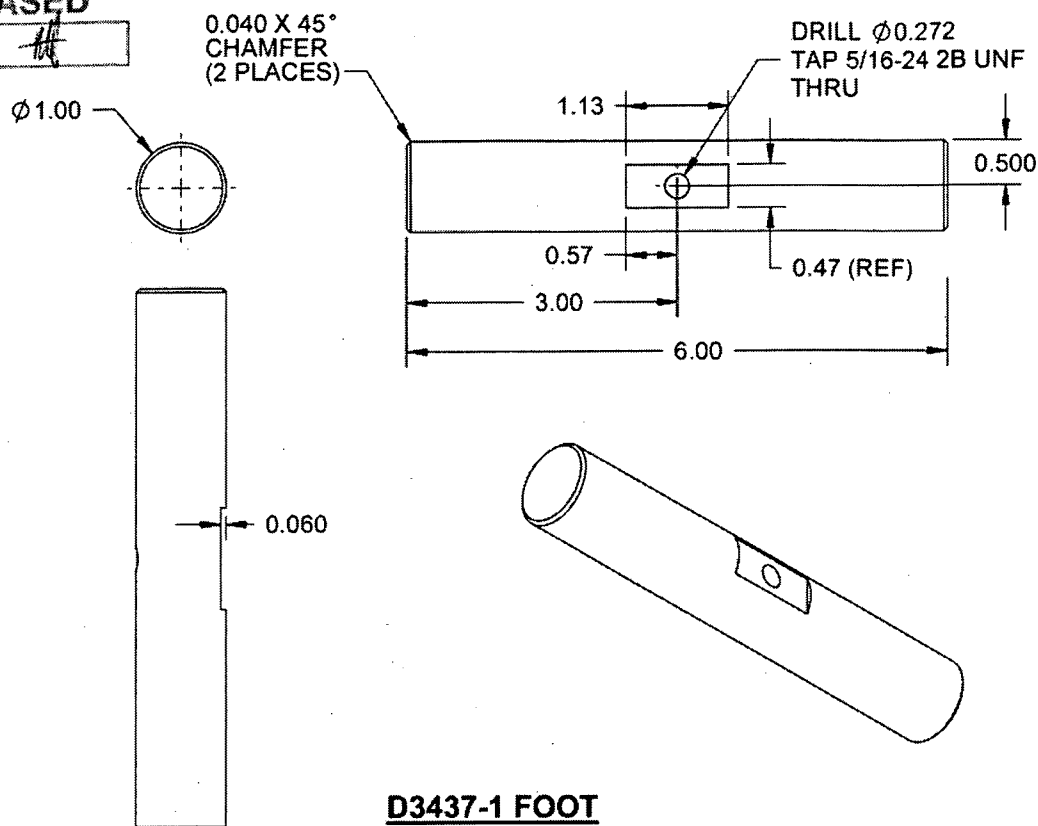
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CHECKED 	APPROVED 	DRAWING NO. D3437	REV. B SHEET 3 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

RELEASED

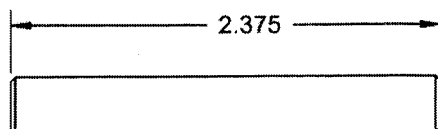
05-08-16



D3437-1 FOOT

D3437-1 FOOT:

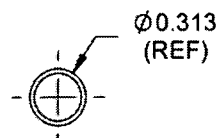
- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



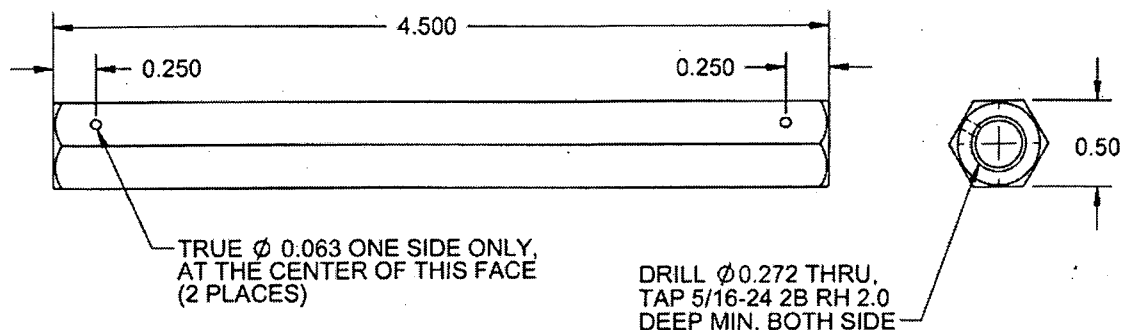
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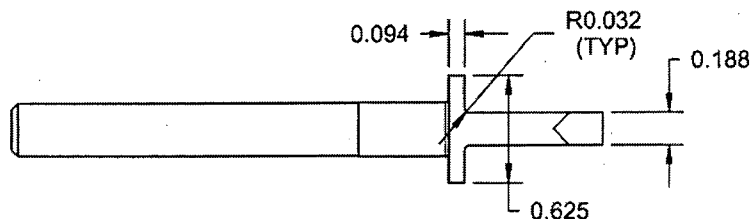
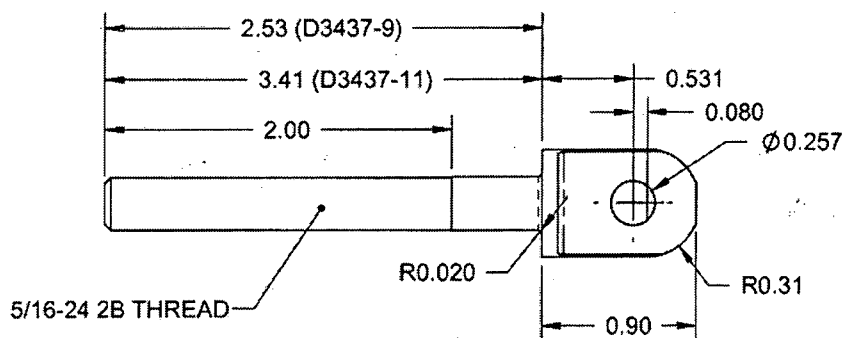
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3437	REV. B SHEET 4 OF 4
DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**05-08-16 *[Signature]***D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

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DART AEROSPACE LTD		Work Order:	41954
Description: Strut		Part Number:	D 3437-5
Inspection Dwg: , Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x | Prototype

[illegible]

Measured by:	DJP
Date:	08/11/05

Audited by:	<i>[Signature]</i>
Date:	08/11/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	